

Date: Thursday, 07/12/2006 9:02:02 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 UTILITY BASKET
Job Number : 21174	
Estimate Number : 10920	
P.O. Number : N/A	Part Number : D407663011
This Issue : 07/12/2006 S.O. No. : N/A	Drawing Number : D2955 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 21174	Material : N/A
Written By : _____	Due Date : 05/05/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:F 05.10.19 Added D2728-3 & AN960JD416L KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D407-663-011CHG002

KS 04.08.09 (1)

2.0	21174A	407 BASKET BASE ASSEMBLY
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**Comment:** Sub-Component 407 BASKET BASE ASSEMBLY

D2948-041

3.0	21174B	407 BASKET LID
-----	--------	----------------

**Comment:** Sub-Component 407 BASKET LID

D2952-041

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass _____

see attached

Date: Thursday, 07/12/2006 9:02:02 AM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

9.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label

10.0

D2851145

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 d2851-145 Placard

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper

Date: Thursday, 07/12/2006 9:02:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2961

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D22961 Label _____

13.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-20A Bolt _____

14.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-14A Bolt _____

15.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-22A Bolt _____

16.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN5-17A Bolt _____

Date: Thursday, 07/12/2006 9:02:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN521A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN5-21A Bolt

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer

Date: Thursday, 07/12/2006 9:02:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5)

Date: Thursday, 07/12/2006 9:02:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



sel 7 Hader



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024.

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D2852

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch
1 D2852 Label B25124

31.0

D2984

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch
1 D2984 Label B12605

32.0

D407301011

Center Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch
1 D407-301-011 Center Bracket Kit B21171

33.0

D407302011

Outboard Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

✓ Qty Part Number Description Batch
1 D407-302-011 Outboard Bracket Kit B22091

Date: Thursday, 07/12/2006 9:02:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 21174

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN3-11A Bolt M4067

35.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 AN960JD10 Washer M100743

36.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 MS21042L3 Nut (or -3) M101917

U 6/12/07

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 06/12/07

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-663-011

Location: _____

PPP Rev: C

U 6/12/07 (1)

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

U 06/12/07 (1)

Job Completion



U 06.12.07

75/35

DART AEROSPACE LTD	Work Order:	21174
Description: 407 Utility Basket	Part Number:	D407-663-011
Dwg: D2955 Rev. B	Qty:	1
Ref: ICA-D407-663 Rev. 0 page 27		Page 1 of 2

Step	Location	Procedure	By	Date	Qty																																																																																												
1	DC	Issue Travelers for: D407-663-011 407 Utility Basket <u>Batch 21174</u> D2948-041 407 Basket Base <u>21174</u> D2952-041 407 Basket Lid <u>21174</u>	JK	05.10.19	1																																																																																												
2	DC	Photocopy bluefile and create labels per PPP D407-663-011 CHG002																																																																																															
3	FP	Powder Coat Gloss White (Ref: 4.3.5.2) D2948-041 Base and Powder Coat Gloss White (Ref: 4.3.5.1) D2952-041 Lid as per QSI 005 4.3.	N/A																																																																																														
4	QC3	Inspect Powder Coat																																																																																															
5	GA	Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr><td>1</td><td>D2332-041</td><td>Prop Assembly</td><td>B 28246</td></tr> <tr><td>1</td><td>D2530</td><td>Handle Weldment</td><td>B 28997</td></tr> <tr><td>2</td><td>D2535</td><td>Spring</td><td>B 25087</td></tr> <tr><td>2</td><td>D2537</td><td>Bushing</td><td>B 29536</td></tr> <tr><td>2</td><td>D2728-3</td><td>Label</td><td>B 22553</td></tr> <tr><td>1</td><td>D2851-145</td><td>Placard</td><td>B 21197</td></tr> <tr><td>2</td><td>D2931</td><td>Bumper</td><td>B 21139</td></tr> <tr><td>1</td><td>D2961</td><td>Placard</td><td>B 12077</td></tr> <tr><td>2</td><td>AN3-20A</td><td>Bolt</td><td>M 15432</td></tr> <tr><td>2</td><td>AN4-14A</td><td>Bolt</td><td>M 100188</td></tr> <tr><td>2</td><td>AN4-22A</td><td>Bolt</td><td>M 17280</td></tr> <tr><td>2</td><td>AN5-17A</td><td>Bolt</td><td>M 102140</td></tr> <tr><td>2</td><td>AN5-21A</td><td>Bolt</td><td>M 1053821</td></tr> <tr><td>4</td><td>AN960JD416</td><td>Washer</td><td>M 6085</td></tr> <tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M 101237</td></tr> <tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M 100564</td></tr> <tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M 102455</td></tr> <tr><td>4</td><td>AN970-4</td><td>Washer x1 - m 106151 - 3x m 102380</td><td></td></tr> <tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M 14393</td></tr> <tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M 101917</td></tr> <tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M 19185</td></tr> <tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M 102171</td></tr> </tbody> </table> Identify as D2955-041	Qty	Part Number	Description	Batch	1	D2332-041	Prop Assembly	B 28246	1	D2530	Handle Weldment	B 28997	2	D2535	Spring	B 25087	2	D2537	Bushing	B 29536	2	D2728-3	Label	B 22553	1	D2851-145	Placard	B 21197	2	D2931	Bumper	B 21139	1	D2961	Placard	B 12077	2	AN3-20A	Bolt	M 15432	2	AN4-14A	Bolt	M 100188	2	AN4-22A	Bolt	M 17280	2	AN5-17A	Bolt	M 102140	2	AN5-21A	Bolt	M 1053821	4	AN960JD416	Washer	M 6085	2	AN960JD416L	Washer	M 101237	4	AN960JD516	Washer	M 100564	2	AN960JD8	Washer	M 102455	4	AN970-4	Washer x1 - m 106151 - 3x m 102380		2	MS20600AD4W3	Rivet	M 14393	2	MS21042L3	Nut (or -3)	M 101917	4	MS21042L4	Nut (or -4)	M 19185	4	MS21042L5	Nut (or -5)	M 102171	ml	06/12/06	1
Qty	Part Number	Description	Batch																																																																																														
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6	QC5	Inspect work to Step 5		06.12.06	1																																																																																												

RELEASED
11/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21174
Description: 407 Utility Basket	Part Number:	D407-663-011
Dwg: D2955 Rev. B	Qty:	1
Ref: ICA-D407-663 Rev. 0 page 27		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																				
7	KP	Pick: Packing Kit (Note: D2955-041 is on BOM as parts listed in Step 5). <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>✓ 1</td> <td>D2852</td> <td>Label</td> <td>B25124</td> </tr> <tr> <td>✓ 1</td> <td>D2955-041</td> <td>Basket Assembly</td> <td>B21174B</td> </tr> <tr> <td>✓ 1</td> <td>D2984</td> <td>Label</td> <td>B12605</td> </tr> <tr> <td>✓ 1</td> <td>D407-301-011</td> <td>Center Bracket Kit</td> <td>B21177</td> </tr> <tr> <td>✓ 1</td> <td>D407-302-011</td> <td>Outboard Bracket Kit</td> <td>B22090</td> </tr> <tr> <td>✓ 6</td> <td>AN3-11A</td> <td>Bolt</td> <td>M14069</td> </tr> <tr> <td>✓ 6</td> <td>AN960JD10</td> <td>Washer</td> <td>M150743</td> </tr> <tr> <td>✓ 6</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M101917</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	✓ 1	D2852	Label	B25124	✓ 1	D2955-041	Basket Assembly	B21174B	✓ 1	D2984	Label	B12605	✓ 1	D407-301-011	Center Bracket Kit	B21177	✓ 1	D407-302-011	Outboard Bracket Kit	B22090	✓ 6	AN3-11A	Bolt	M14069	✓ 6	AN960JD10	Washer	M150743	✓ 6	MS21042L3	Nut (or -3)	M101917			
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8	QC4	Inspect Kit 100% for Completeness on the W/O																																							
9	PK	Identify and pack for shipping as per PPP D407-663-011																																							
10	AC	Cost / part: _____																																							
11	DC	Close W/Order and Ensure Travellers Attached Inspect Level 21 Travellers: D407-663-011 D2948-041 D2952-041																																							

Rev	Date	Change	Revised By	Approved
A	00.03.23	New Issue	EC	
B	00.07.06	Added K10001	EC	
C	00.08.10	Added D2984 (mpp 2080)	EC	
D	01.03.08	Changed pick list (mpp 2119)	EC	
E	03.11.26	Reformat; Incorporated D2955-041	KJ/RF	
F	05.10.19	Added D2728-3 & AN960JD416L	KJ/JLM	

RELEASED
 11/5/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: HP Date: 04/12/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY	SCALE NTS
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2 A	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2 A	AN960JD8	WASHER
4	AN970-4	WASHER
2 A	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF

#00.09.08
RF

#00.09.08
RF

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21174

RELEASED
00.07.18 #

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D2952-041 BASKET
LID ASSEMBLY

D2851-145 PLACARD (1)
D2961 PLACARD (1)

D2948-041 BASKET
BASE ASSEMBLY

PROP AR

AN4-1
AN960
MS210
(2 PL)

D2535 SPRING (1)
D2537 BUSHING (1)
(2 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

21174
RELEASED
00.07.18

DETAIL C
SPRING DETAIL

DETAIL A
HINGE DETAIL

DRAWN BY

RF

APPROVED

#

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2955

REV. B

SHEET 2 OF 2

TITLE

BASKET ASSEMBLY

SCALE

NTS

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 01, 2004
02:00 pm

Work Order No : 0021174
Project Name : D407-663-011
Project For : WK435
Work Order Type : Main
Main WO Number :
House Part Number : *D407-663-011
Description : Heli-Utility-Basket
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 07-01-04
Est Finish Date : 08-26-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Thursday, 11/24/2005 8:10:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 BASKET LID
Job Number : 21174B	
Estimate Number : 10917	
P.O. Number : <i>N/A</i>	Part Number : D2952041
This Issue : 11/24/2005 S.O. No. : <i>N/A</i>	Drawing Number : D2952 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/30/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:C 03.11.26 Reformat KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6TS0750W062	6061-T6 SQ Tube.75x.062W
-----	-------------------	--------------------------



Comment: Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s)
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall
 (M6061T6TS0.750W.062)
 Batch: *M16441*

PD 06-11-14 ①

2.0	M5052H32S080	5052-H32 .080 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s)
6061-T6 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080"
 (M5052H32S.080) (*M6061T6S 0.80*)
 Batch: *M102448*
 Identify as D2952-11

PD 06-11-14 ①

3.0	D2953077	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2953-077 Spacer *B13267* → 1 *B22095* → 1

PD 06-11-14 ①

4.0	D2953175	Spacer
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D2953-175 Spacer *B22096*

PD 06-11-14 ①

Date: Thursday, 11/24/2005 8:10:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 21174B

Part Number: D2952041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2957 Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
6 D2957 Mounting Plate B21198

PD 06-11-14 (1)

6.0 M1100H14ES34X051F Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total : 15.7500 sf(s)

Pick:

Qty Part Number Description Batch
15sf M1100H14ES-3/4x.051F Mesh M17390

PD 06-11-14 (1)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD Batch: M100237

PD 06-11-14 (1)

8.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

106/11/14 (2)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

yl 06/11/13 X1

10.0 D2983 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate B13268

PD 06-11-14 (1)

Date: Thursday, 11/24/2005 8:10:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 21174B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS20600AD4W2

Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Rivet

M4747

PD 06-11-15 (1)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

PD 06-11-15 (1)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 12 05 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 06/12/06

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m 06/12/06

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/12/07 (1)

Job Completion



→ 12.1

QC 5 inspection

M 06/11/16 (1)

(permanent change)

Date: Thursday, 11/24/2005 8:09:58 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	407 BASKET BASE ASSEMBLY
Job Number :	21174A		
Estimate Number :	10912		
P.O. Number :	N/A	Part Number :	D2948041
This Issue :	11/24/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2948 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	B
	Type :	Material :	N/A
	LARGE FAB ASSY	Due Date :	1/30/2006
Written By :		Qty:	1 Um: Each
Checked & Approved By :			
Comment :	Est Rev:E 04.08.09 Revised Step 1 KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 48.9993 f(s)/Unit Total: 48.9993 f(s) Material: 304/316 SS tube 0.049" wall M15256-310' (M304TS0.750W.049) M12476-310' Batch: M19161-17.08' M15357-3.92'		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948		
3.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	D23273	Spacer Bushing
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2327-3 Spacer 528073		

Date: Thursday, 11/24/2005 8:09:58 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASS

Job Number: 21174A

Part Number: D2948041

Job Number:



Seq. #:	Machine Or Operation:	Description:
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6.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D2581	Mounting Bracket

Batch:

021881

PD 06-11-15 (1)

7.0	D2954	Mounting Plate
-----	-------	----------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description
4	D2954	Mounting Plate

Batch:

012525

PD 06-11-15 (1)

8.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 33.6000 sf(s)/Unit Total: 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32sf	M304EX0.75-16F	SS Expanded Metal	M102394

M102394

PD 06-11-15 (1)

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and DeburIdentify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948
Identify properly as D2948-1/-3/-7/-9

3-Remove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Debur as required.

A/R SS Rod Batch: M101134

PD 06-11-15 (1)

10.0	QC5/9	WELD INSPECTION
------	-------	-----------------



Comment: WELD INSPECTION

PD 06/11/16 (1)

RECEIVED 32A 71 13

1418



RECEIVED 32A 71 13
JAN 14 1971

Date: Thursday, 11/24/2005 8:09:58 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 21174A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per OSI 00543

FC 06/12/05 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/12/06

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 06/12/06

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/12/07

Job Completion



u 06.12.07

CONFIDENTIAL

SECRET

30 Jan

1500

10

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20
21

NO. 74AWS D17.1.2001
QUALIFICATION TEST RECORDName Pat Duval
Joint Welding Procedure Tig
Part number and Job number 2952041 / B21174 B

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☐ DC ☐ Backing YES ☐ NO ☒

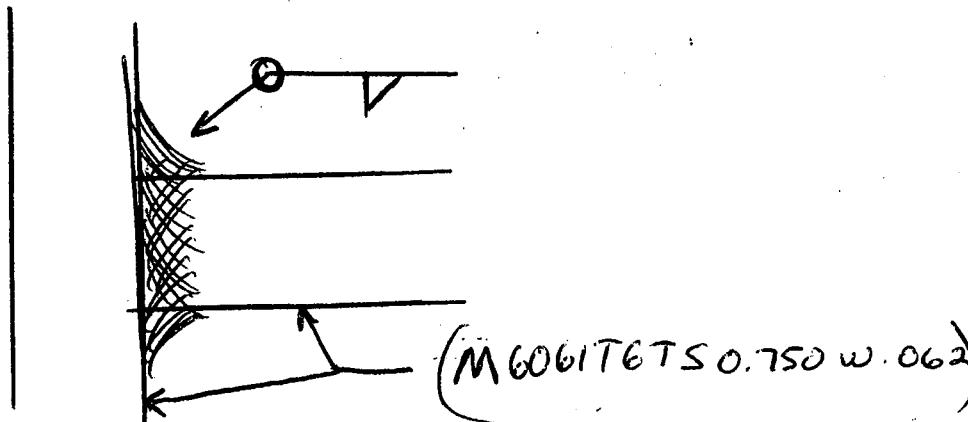
	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/08 Qualifier David Duval

Job Costing Report

Art Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:05 am

Subs?

Work Order No : 0021174
Project Name : D407-663-011
Project For : WK435
Work Order Type : Main
Main WO Number :
House Part Number : *D407-663-011
Description : Heli-Utility-Basket
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 07-01-04
Est Finish Date : 08-26-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.75	100.00		
Production Cost :	0.00	32.04	100.00	0.00	32.04
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	32.04	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	32.04			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-32.04)

35

DART AEROSPACE LTD	Work Order:	21174
Description: 407 Basket Base	Part Number:	D2948-041
Dwg: D2948 Rev. B	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	JP	04.07.05	1																				
2	LG	Cut (2) D2948-5, 3/4" x 3/4" square tubing as per Dwg D2948 Material: 304/316 SS tube 0.049" wall ^{120"} (M304TS0.750W.049) Identify for D2948-5 Batch: <u>B15357</u>	JP	05-9-27	1																				
3	LG	Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019	JP	05-9-27	1																				
4	WS	Trim to length as per Dwg D2948 and Deburr Identify as D2948-5																							
5	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2948 Material: 304/316 SS tube 0.049" wall (M304TS0.750W.049) Identify properly as D2948-1/-3/-7/-9 Batch: _____																							
6	WS	Drill holes in D2948-3/-7 as per Dwg D2948. Deburr as required.																							
7	KP	Weld as per Dwg D2948 and QSI 004. Deburr as required. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2327-3</td><td>Spacer</td><td>_____</td></tr><tr><td>2</td><td>D2581</td><td>Mounting Bracket</td><td>_____</td></tr><tr><td>4</td><td>D2954</td><td>Mounting Plate</td><td>_____</td></tr><tr><td>32sf</td><td>M304EX0.75-16F</td><td>SS Expanded Metal</td><td>_____</td></tr></table>	Qty	Part Number	Description	Batch	1	D2327-3	Spacer	_____	2	D2581	Mounting Bracket	_____	4	D2954	Mounting Plate	_____	32sf	M304EX0.75-16F	SS Expanded Metal	_____			
Qty	Part Number	Description	Batch																						
1	D2327-3	Spacer	_____																						
2	D2581	Mounting Bracket	_____																						
4	D2954	Mounting Plate	_____																						
32sf	M304EX0.75-16F	SS Expanded Metal	_____																						
8	QC9/6	Inspect welding and dimensions																							
9	WS	Go to traveler D407-663-011 for Finishing																							

Rev	Date	Change	Revised By	Approved
A	00.03.22	New Issue	EC	
B	00.08.09	New dwg rev (mpp2078)	EC	
C	00.11.21	Added D2948-5 to pick list	EC	
D	03.11.26	Reformat; Incorporated D2948-5	KJ/RF	

RELEASED
04.01.09

Work Order		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
05-9-27	1	Please add in 120"	DP	05-9-27			

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

35

DART AEROSPACE LTD	Work Order:	21174
Description: 407 Basket Lid	Part Number:	D2952-041
Dwg: D2952 Rev. B	Qty:	
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	21	04.07.05	1																				
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2952 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall (M6061T6TS0.750W.062) Identify as D2952-1/-3/-5/-7/-9 Batch: 21557																							
3	WS	Cut D2952-11 corner gussets as per Dwg D2952 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080" (M5052H32S.080) Batch: _____ Identify as D2952-11																							
4	WS	Drill holes in D2952-3 as per Dwg D2952. Deburr.																							
5	WS	Weld as per Dwg D2952 as per QSI 004. Deburr as required. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2953-077</td><td>Spacer</td><td>_____</td></tr><tr><td>1</td><td>D2953-175</td><td>Spacer</td><td>_____</td></tr><tr><td>6</td><td>D2957</td><td>Mounting Plate</td><td>_____</td></tr><tr><td>15sf</td><td>M1100H14ES-3/4x.051F</td><td>Mesh</td><td>_____</td></tr></table>	Qty	Part Number	Description	Batch	2	D2953-077	Spacer	_____	1	D2953-175	Spacer	_____	6	D2957	Mounting Plate	_____	15sf	M1100H14ES-3/4x.051F	Mesh	_____			
Qty	Part Number	Description	Batch																						
2	D2953-077	Spacer	_____																						
1	D2953-175	Spacer	_____																						
6	D2957	Mounting Plate	_____																						
15sf	M1100H14ES-3/4x.051F	Mesh	_____																						
6	QC9/6	Inspect welding and dimensions																							
7	FP	Chemical Conversion Coat as per QSI 005 4.1																							
8	QC3	Inspect Conversion Coat																							
9	GA	Assemble Label Plate as per Dwg D2952 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2983</td><td>Label Plate</td><td>_____</td></tr><tr><td>34</td><td>MS20600AD4W2</td><td>Rivet</td><td>_____</td></tr></table>	Qty	Part Number	Description	Batch	1	D2983	Label Plate	_____	34	MS20600AD4W2	Rivet	_____											
Qty	Part Number	Description	Batch																						
1	D2983	Label Plate	_____																						
34	MS20600AD4W2	Rivet	_____																						
10	QC5	Inspect work to Step 9																							
11	GA	Go to traveler D407-663-011 for Finishing																							

Rev	Date	Change	Revised By	Approved
A	00.03.22	New Issue	EC	
B	00.07.12	Up dated Dwg rev.B	EC	
C	03.11.26	Reformat	KJ/RF	

RELEASED
04.01.09

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
05/9/27		Replace old with new 1.20"	ASB				

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

RELEASED
00.07.18

SEE DETAIL B

175

ENTER
ASKET

D2952-3

D2953-175 (REF)
SEE DETAIL A

ENLARGE $\phi 0.323$
TO $\phi 0.375$ AND
WELD D2953-077
EQUAL SPACE
BOTH SIDES

D2957 (REF)

TYP

DETAIL D

SHOP COPY

5 (TYP) RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 21174

1.25 ± 0.03
0.00

DETAIL E

D2957 (REF)

6.00

DRILL $\phi 0.375$ HOLE
AND INSTALL D2953-175
SEE DETAIL A

MS20600AD4W2
RIVETS

MESH

D2983
LABEL PLATE

$R0.13 \pm 0.03$

0.25

SECTION F-F

3

D2952-11 GUSSET
(4 PLACES)

0.38 (TYP)

5

TYP

TYP

DETAIL B

WELD ALL JOINTS
AS SHOWN

45°

	DESCRIPTION	LENGTH A	LENGTH B
041	BASKET LID ASSEMBLY	N/A	N/A
1	FRAME MEMBER	N/A	84.00
3	FRAME MEMBER	N/A	23.50
5	FRAME MEMBER	22.00	N/A
7	FRAME MEMBER	15.88	N/A
9	FRAME MEMBER	24.25	N/A
11	GUSSET	N/A	N/A
175	SPACER	N/A	N/A
077	SPACER	N/A	N/A
	MOUNTING PLATE	N/A	N/A
	LABEL PLATE	N/A	N/A
	MS20600AD4W2 RIVETS	N/A	N/A

NOTES:

- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.063
- 2) MESH MATERIAL: 5005-H34 OR 3003-H14
- 3) GUSSET MATERIAL: 6061-T6 (QQ-A-250/11 (QQ-A-250/8) (3.00 x 3.00) 0.080 THICK
- 4) WELD PER DART QSI 004
- 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE
- 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL WELDS (4 PLS) BOTTOM SIDE FOR GUSSET
- 7) TRANSFER D2983 LABEL PLATE HOLES USING D2983 ONTO FRAME USING MS20600AD4W2
- 8) FINISH: CHEMICAL CONVERSION COAT PER DART POWDER COAT WHITE (REF. 4.3.5.1) PER DART
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS

00.07.06

CHANGE FROM SHEET TO MESH;
ADD D2952-7/-9/-11

00.01.14

NEW ISSUE

DRAWN BY

RF

APPROVED

RF

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2952

REV. B

SHEET 1 OF 1

TITLE

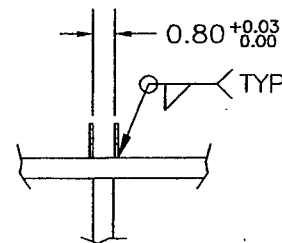
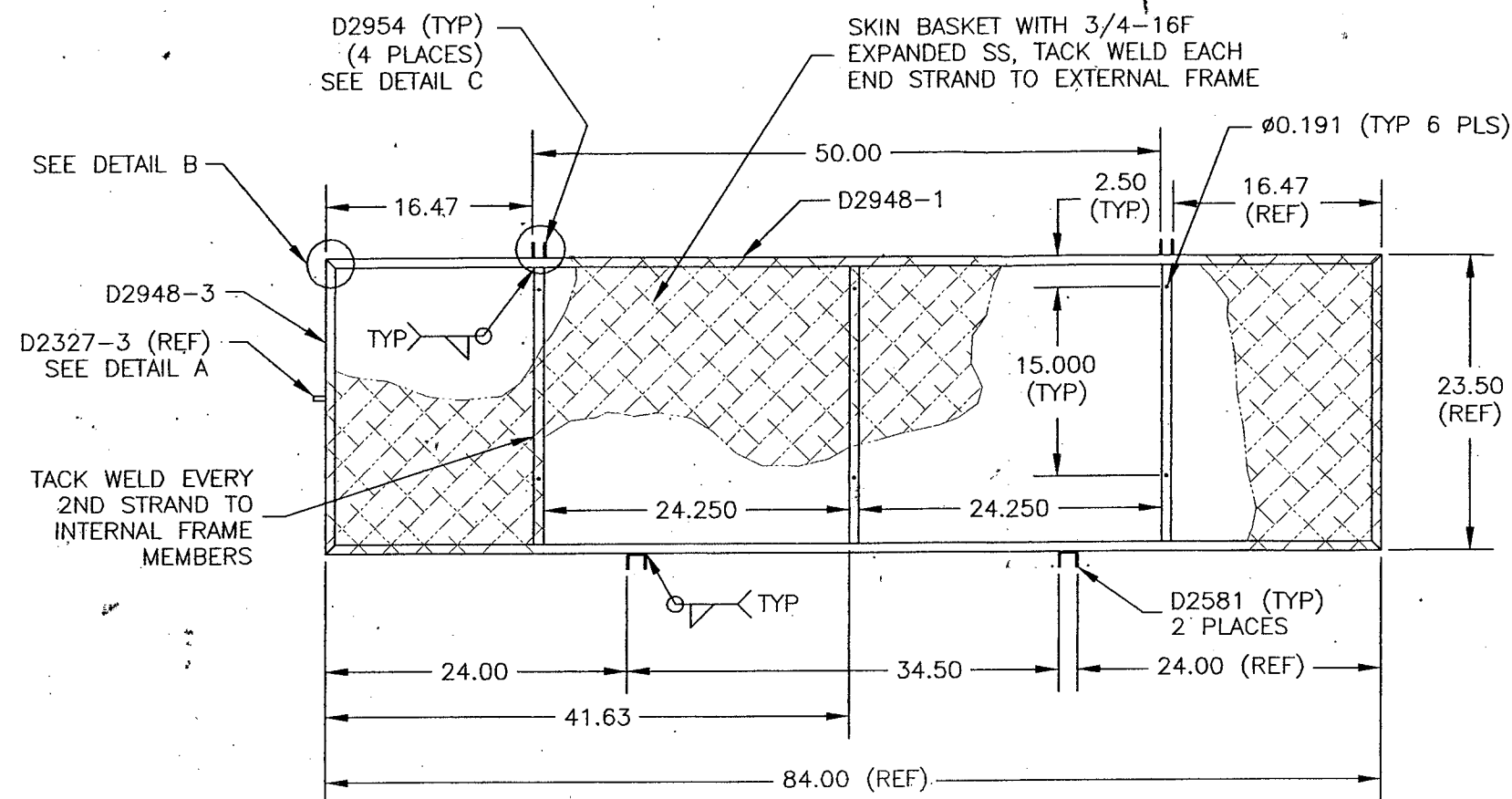
BASKET LID ASSEMBLY

SCALE

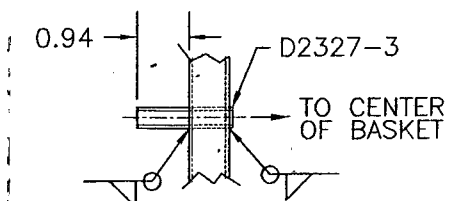
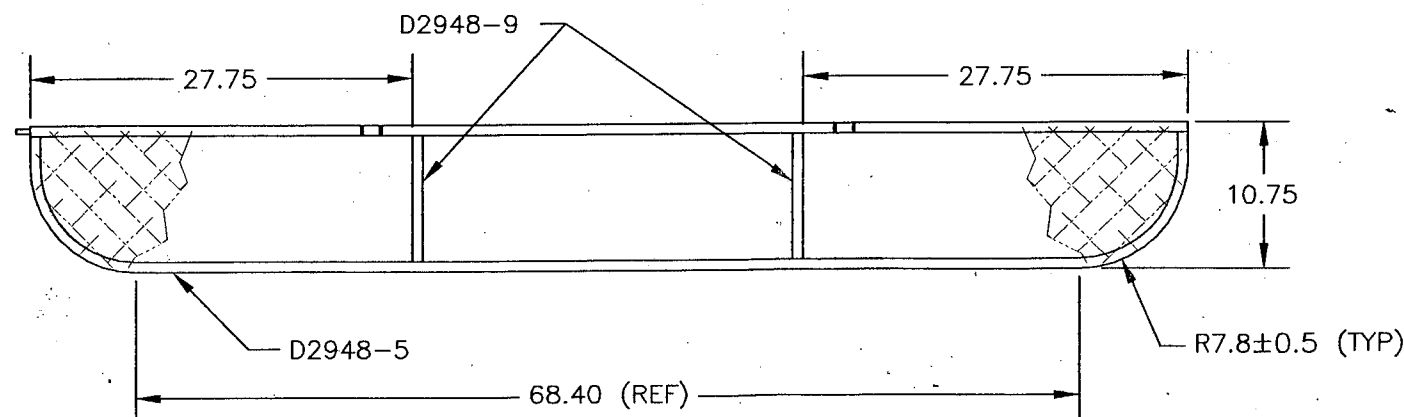
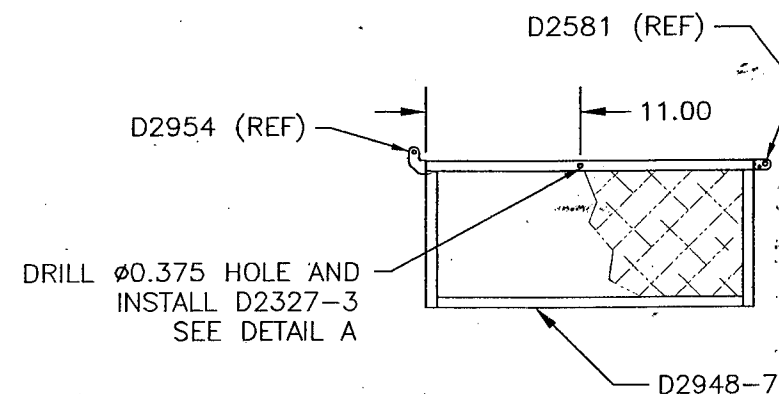
NTS

COPY ISSUED

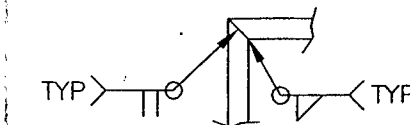
RELEASED
00.07.18



DETAIL C



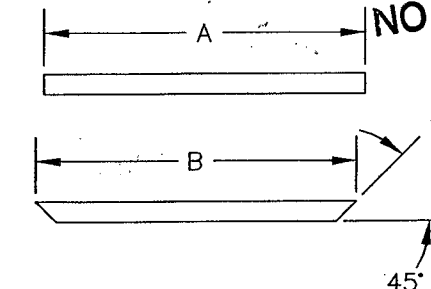
DETAIL A
SPACER INSTALLATION



DETAIL B
WELD ALL JOINTS
AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 21174



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
WELD PER DART QSI 004
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY
CHECKED	RF	APPROVED
DATE	00.07.17	TITLE
		BASKET BASE ASSEMBLY

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2948
REV. B
SHEET 1 OF 1
SCALE NTS

14.17 65.55

